



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4464-041

Job Sheet 170434



Part No: D4464-041

Job Qty: 1 ea

Part Name: Fuel Tank Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 3/16/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV H IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG REV PE1 DD VERF:JLM IPP REV:E 14.06.13 AS PER DWG REV.E DD VERF:JLM IPP REV:F 14.07.21 AS PER DWG REV.F DD VERF:JLM IPP REV:G 15.01.15 AS PER DWG REV.G DD VERF:JLM IPP REV:H 15.03.04 AS PER DWG REV.H9 DD VERF:JLM IPP REV:I 15.06.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials



Container No: S037529



Part: D4464-041

Job No: 170434

Serial No/Batch: S037529

Revision: I

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/04/18



Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/14/18	0.00	0.00	Start Up Large Fab-7		D.M.L 18-1-31
100	Large Fab	1 pcs		3/14/18	0.00	10.34	Large Fab 2	CPC	D.H.E 18-1-31
110	QC	1 pcs		3/14/18	0.00	0.00	QC9		D 180131
112	Small Fab	1 pcs		3/14/18	0.17	1.53	Small Fab-6		ES
114	QC	1 pcs		3/14/18	0.00	0.00	QC5		ES
120	Large Fab	1 pcs		3/15/18	0.00	10.34	Large Fab 2		CPC
123	Small Fab	1 pcs		3/15/18	0.00	1.53	Small Fab-6		ES
140	Large Fab	1 pcs		3/15/18	0.00	10.34	Large Fab 2		CPC
141	QC	1 pcs		3/15/18	0.00	0.00	QC9		PD 13-02-12
142	QC	1 pcs		3/15/18	0.00	0.00	QC5		PD 13-02-12
143	Outsource	1 pcs		3/15/18	0.00	0.00	Outsource2		ALB FEB 15 2018
145	Packaging	1 pcs		3/15/18	0.00	0.00	Packaging2		ALB FEB 15 2018
147	QC	1 pcs		3/15/18	0.00	0.00	QC6		38
150	HandFinish	1 pcs		3/15/18	0.00	1.32	HandFinish1		18-02-22
160	QC	1 pcs		3/15/18	0.00	0.00	QC7-3		ES
164	Small Fab	1 pcs		3/15/18	0.00	1.53	Small Fab-6		ES DAS
169	QC	1 pcs		3/15/18	0.00	0.00	QC5		38
170	SprayPaint	1 pcs		3/15/18	0.00	1.73	Spray Paint		AB MAR 04 2018
180	QC	1 pcs		3/15/18	0.00	0.00	QC14		38
190	Small Fab	1 pcs		3/16/18	0.00	1.53	Small Fab-6		ES
200	QC	1 pcs		3/16/18	0.00	0.00	QC5		38
210	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-2		9-89 Smf
220	QC21-SA	1 Ea		3/16/18	0.00	0.00	QC21		DAS

Part Op 100 - 1- Weld D4023-3 cap as per dwg D4464 2- Buff alodine on all edges welded parts.

Descriptions: 112 - 1- Wet install baffles to front and back panel using rivet and Proseal as per dwg A/R Proseal 890B Batch: 138708

Batch: 138708

120 - 1- Use fixture to weld D4125 bolws to D4463-13 as per dwg. 2- Tack Weld D4463-3 to side, front a back panel.

123 - Transfer drill and c/sink D4975-1 bracket to bottom bracket, wet install as per dwg Proseal 890B Batch: 138708 Install hinge wet with proseal as per dwg A/R Proseal 890B Batch: 138708 Install D4000-9 grommets as per dwg, ***D4000-1 FLAT SURFACE MUST BE INSTALL UPWARDS AS PER DWG*** Install fitting D4000-1 wet with proseal as per dwg A/R Proseal 890B Batch: 138708

140 - Weld top D4463-1 using DT9811 and DT9810 Finish welding the rest of the tank

143 - ISSUE P/O: 039037 LPI INSPECTION

FEB 15 2018

150 - 1- Alodine on tank. No alodine inside

164 - 1- Brush Proseal 890A on all internal sheet metal folds Proseal 8990A Batch: 2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890B A/R Proseal 890B Batch:

170 - ***MASK PROIOR PRIME AND PAINT AS PER DWG*** PRIME TEMPO GREY AS PER DWG AND QSI PRIMER BATCH: 138646 PAINT FLAT GREY AS PER DWG AND QSI PAINT BATCH: 136996

190 - 1- Install placards, fuel sender, tank support, fuel filler splash guard assy, fuel cap as per dwg 2- Abrade surface with red scotch brite and install cushion using contact cement A/R Contact Cement Batch:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3999-7	Corner	1 Ea (1 ea)	90-Start up Operation	156521
D4000-045	Fuel Pickup Fitting Assembly	1 Ea (1 ea)	90-Start up Operation	1160585
D4000-1	Fuel Supply Fitting	1 Ea (1 ea)	90-Start up Operation	1161003-2
D4000-5	Fuel Tank Vent Fitting	1 Ea (1 ea)	90-Start up Operation	158936
D4000-9	Grommet	3 Ea (3 ea)	90-Start up Operation	F152269
D4008-11	Hinge Half	1 Ea (1 ea)	90-Start up Operation	165235
D4057-1	Retaining Ring	3 Ea (3 ea)	90-Start up Operation	F156450
D4125-1	Fwd Sediment Bowl	1 Ea (1 ea)	90-Start up Operation	5003432
D4125-3	Aft Sediment Bowl	1 Ea (1 ea)	90-Start up Operation	156459
D4462-1	Baffle	1 Ea (1 ea)	90-Start up Operation	5006587
D4462-3	Baffle	1 Ea (1 ea)	90-Start up Operation	F160611
D4463-041	Tank Top Assembly	1 Ea (1 ea)	90-Start up Operation	F163300
D4463-11	Tank Front	1 Ea (1 ea)	90-Start up Operation	F163009
D4463-3	Tank Aft End	1 Ea (1 ea)	90-Start up Operation	F163531
D4463-5	Tank Upper Cut Out	1 Ea (1 ea)	90-Start up Operation	F1606751
D4463-7	Tank Fwd End	1 Ea (1 ea)	90-Start up Operation	F160612
D4463-9	Tank Back	1 Ea (1 ea)	90-Start up Operation	F160614
AN3-5A	Bolt	24 Ea (24 ea)	190-Small Fab	503237
AN3-7A	Bolt	4 Ea (4 ea)	190-Small Fab	PM1011461 50
AN3H5A	Bolt	5 Ea (5 ea)	190-Small Fab	137371 50
D3997-11	Placard	1 Ea (1 ea)	190-Small Fab	F160132 50
D3997-17	Placard	1 Ea (1 ea)	190-Small Fab	F152302 50
D3997-29	Placard	1 Ea (1 ea)	190-Small Fab	F160134 50
D3997-43	Placard	1 Ea (1 ea)	190-Small Fab	5027106 50
D3997-5	Placard	2 Ea (2 ea)	190-Small Fab	160135 50
D4008-041	Fuel Filler Splash Guard Assembly	1 Ea (1 ea)	190-Small Fab	162636 50
D4023-3	Cap And Flange	1 Ea (1 ea)	190-Small Fab	
D4062-041	Tank Support Assembly	1 Ea (1 ea)	190-Small Fab	F159849
D4463-13	Tank Bottom	1 Ea (1 ea)	190-Small Fab	
D4577-041	Fwd Access Panel Assembly	1 Ea (1 ea)	190-Small Fab	F146803
D4577-1	Rear Access Panel	1 Ea (1 ea)	190-Small Fab	F146801 5
D4577-3	Middle Access Panel	1 Ea (1 ea)	190-Small Fab	F146093 5
D4968-1	Side Cushion	1 Ea (1 ea)	190-Small Fab	16A63
D4975-1	Bracket	1 Ea (1 ea)	190-Small Fab	F163487
MS20426AD4-4	Rivet	4 Ea (4 ea)	190-Small Fab	
MS20470AD4-4	Rivet, Universal Head	165 Ea (165 ea)	190-Small Fab	5027554
MS20470AD4-6	Rivet, Universal Head	8 Ea (8 ea)	190-Small Fab	FM133077-50
MS21042L3	Nut	4 Ea (4 ea)	190-Small Fab	5033576 50
NAS1149D0332J	Washer	12 1/4 Ea (13 ea)	190-Small Fab	500606 50
NAS1149D0363J	Washer	24 Ea (24 ea)	190-Small Fab	5015209 5
D4025-5	Fuel Quantity Sender	1 Ea (1 ea)	190-Small Fab	5156462 50

D4463-041-D4404-5

2 F160607 Small Fabs

Part Specifications

Specifications could not be found.

NAS1149D0316J

1X

190 Small Fab

Plex 1/19/18 2:21 PM dart.gauthier.daniel

134502-2



S037529



Fuel Tank Assembly

PART NO: D4464-041

Original Serial #: S037529

Revision:

Operation:

Change No:

Start up Operation 01/31/18
Job No: 170434



Master Unit 000320

Job No

170434

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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
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**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34975	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO039037
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

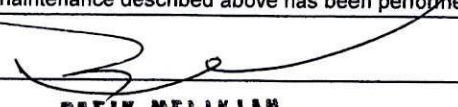
CARRY OUT NDT ON:

1 FUEL TANK ASSY P/N# D4464-041 , J/S# 170434

5 AFT CROSSTUBES , P/N# D412-664-403 , J/S# 171064, 171065, 171066, 171067, 171068

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13						FEB 14 2018	 DOT-APP 20 53-89
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715							
, UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	
		UAS 38 9-08					

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp DOT-APP 20 53-89	Date: FEB 14 2018
Name: RAFIK MELIKIAN		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039037

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO039037
PO Date: 2/14/18
Due Date:
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170434	D4464-041	Fuel Tank Assembly ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed		1 pcs	0 pcs	1 pcs	\$198.3333/pcs	\$198.33
2	171068	D412-664-403	412 Stainless Steel Aft Crosstubes - High ISSUE P/O TO ACCUREN:	Firmed		1 pcs	0 pcs	1 pcs	\$198.3333/pcs	\$198.33
	171067			Firmed		1 pcs	0 pcs	1 pcs	\$198.3333/pcs	\$198.33
	171066			Firmed		1 pcs	0 pcs	1 pcs	\$198.3333/pcs	\$198.33
	171065			Firmed		1 pcs	0 pcs	1 pcs	\$198.3333/pcs	\$198.33
	171064			Firmed		1 pcs	0 pcs	1 pcs	\$198.3333/pcs	\$198.33
Sub Total:						5	0	5		\$991.67

Grand Total: \$1,190.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness